

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029000**Date Inspected:** 16-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA was tasked with checking the tracking records of the welding in the OBGs. Weld Visual, Magnetic Particle and Ultrasonic Test reports were compared to the tracking record to ensure all welds that were marked complete had documentation of the inspection and types inspections performed. Discrepancies were noted between the records and reports submitted and were corrected by re-inspecting the weld or by contacting the QA inspector involved to submit the appropriate report. This is an on going process to be completed as time and schedule allows.

Welder Wai Kit Lai #2953:

Welder was observed welding fillet welds and PJP welds for the Retro Stiffener at 13E PP119-ERS. The stiffeners mentioned above are the CCO 238 Retro Stiffeners to the "C" side plating. Welder was observed preheating and using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 for the fillet welds and 2170-3 for the partial joint penetration or PJP welds. Welding parameters were verified by QC Inspector John Hays throughout the day and appear to be in compliance with the both WPSs noted above.

Welder Xiao Hua Lou #1291:

Welder was observed welding the longitudinal stiffener attachment fillet welds to the A deck plating in way of the deck access hole at 13E PP124.5 E5.0-DAH. Welder was observed preheating and using Welding Procedure

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Specification (WPS) ABF-WPS-D15-F1200-A- for Shielded Metal Arc Welding (SMAW). Welding parameters as verified by QC Inspector Salvador Merino appear to be in compliance with the WPS noted above.

Welder Mike Jimenez #4671:

Welder was observed performing grinding and weld repairs on the "A" deck plating in way of visually noted indications from the removal of temporary welded attachments throughout the deck plating. Prior to any welding the QC Inspector was observed performing Magnetic Particle Testing verifying the absence of any linear indications in the excavated or ground area. The welder was then observed preheating and welding utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per Request for Weld Repair (RWR) 201301-019. Welding parameters as verified by QC Inspector Barry Drake appear to be in compliance with the WPS noted above. Weld repaired areas were observed ground flush by the welder after welding. As per the RWR noted above, post weld heat treat (PWHT) or Hydrogen Diffusion Postheat (HDPH) are not required for these repairs.

Non-Destructive Testing (NDT)

This QA performed Visual and Magnetic Particle Testing on the following:

13E PP124.5 E5.0-PS1:

o QA Verification (VT, MPT Accept.)

This QA Inspector completed report form TL-6028 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
